

WORK ORDER 2010-~~22~~ 34

Date opened: 14 October 2010

Project: Quick Release Cargo Basket Assembly
Type: Robinson R44 SeriesBatch Quantity: 1 Complete RH Basket Assembly (90610-01-01)
4 Complete LH Basket Assembly (90610-01-02)Approval: SH10-48
Drawing List: DCL906-11, DCL906-12


Fabrication and Assembly Drawing(s)	Description
90610, Rev. 0	Basket Ass'y
90611, Rev. 0	Basket Body Ass'y
90612, Rev. 0	Basket Lid Ass'y
84255, Rev. 0	Handle Installation
84261, Rev. 0	Handle Bar Ass'y
84262, Rev. 0	Handle Bracket Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Welder Signature: _____	Date: _____
 _____	31 MAY 2011
Inspector Signature: _____	Date: _____

Drawing: 90610 Revision 0
 Assembly: 90610-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	90610-01-01	RH Cargo Basket Assembly			
4 Total	90610-01-02	LH Cargo Basket Assembly			
1	90611-01	Basket Body Assembly	Below		
1	90612-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	8093	
1	MS20001P4	Piano Hinge		8104	
1	90627-01	Placard	0.063" Sheet, 6061-T6 Aluminum	10051	
3	49205-14	Bumper	Argus Industries Bumper	10026	
A/R	HR3213-5-02	Blind Rivet		10089	
4	HR3523-5-02	Monel Blind Rivet		10064	
3	40088-14	Fitting	Ancra	10006	
3	AN960-616	Washer		10017/10025	
1	90628-01	Fitting		10105	
1	AN3-15A	Bolt		7077	
1	AN3-17A	Bolt		7077	
4	AN960-10	Washer		10049	
2	AN970-3	Washer		8067	
2	MS21044N3	Nut		10025	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-5-02, HR3523-5-02 Rivets	jc	
Final Inspection	Drawing 90610		jc	

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 90611 Revision 0
 Assembly: 90611-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
1 Total	90611-01-01	RH Basket Body Assembly			
4 Total	90611-01-02	LH Basket Body Assembly			
1	90621-01-01	RH Aft Attachment Hoop			
1	90621-01-02	LH Aft Attachment Hoop			
2	90621-04	Lug	1018 Mild Steel, 5/8" Rod	10087	
1	90622-01-01	RH Forward Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	10087	
1	90622-01-02	LH Forward Attachment Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	10087	
2	69823-02	Lug	1018 Mild Steel, 5/8" Rod	10087	
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	10087	
A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	10087	
A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	10087	
1	84262-01	Handle Bracket Assembly	Below	7007	
1	49215-01	Spacer	1018 Steel, 1/2" Rod	8044	
A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'l's Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90611			
Final Inspection	Drawing 90611			

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Drawing: 90612 Revision 0
 Assembly: 90612-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	90612-01-01	RH Basket Lid Assembly			
4 Total	90612-01-02	RH Basket Lid Assembly			
A/R	69824-01	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	60087	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	7007	
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9010	
A/R	3/4-16F	Mesh	Expanded carbon steel	8014	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 90612			
Final Inspection	Drawing 90612			

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Drawing: 84255 Revision 0
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
5 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2010-27	
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	9091	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		8078	
4	AN3-11A	Bolt		10082	
12	AN960-10	Washer		10082	
6	MS21044N3	Nut		10049	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

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Drawing: 84261 Revision 0
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	10083	
2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	8076	
2	MS20615-4M3	Monel Rivet		7039	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			JK

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

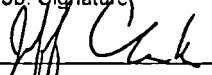
Drawing: 84262 Revision 0
Assembly: 84262-01 Handle Bracket Assembly

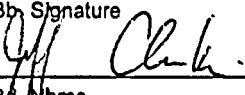
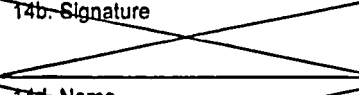
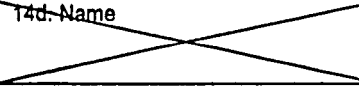
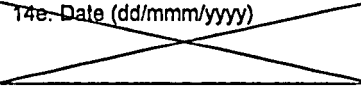
Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube	6076	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

Tag incomplete parts with Work Order # when stored between processes.


Tag complete parts / assemblies with Release Tag prior to storage.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-34
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	LH Cargo Basket	90610-01-02	1	90602-03	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mm/yyyy) 31 May 2011		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-34
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	LH Cargo Basket	90610-01-02	1	90602-04	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature	
		AMF 73-04			
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name	
Jeff Clarke		25 Feb 2011			
14e. Date (dd/mm/yyyy)					
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

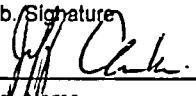
CAN-02

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1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.		
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO2010-34		
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work		
	LH Cargo Basket	90610-01-02	1	90602-05	New		
12. Remarks							
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. 				
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number	
 Jeff Clarke		AMF 73-04					
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)	
Jeff Clarke		23 Feb 2011					
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.							

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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	LH Cargo Basket	90610-01-02	1	90602-02	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mm/yyyy) 02 Feb 2011		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HEU TOW CART

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6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	RH Cargo Basket	90610-01-01	1	90601-02	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			<input type="checkbox"/> Other regulation specified in block 12			
<input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the <u>Canadian Aviation Regulations</u> .			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 07 Dec 2010		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

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